

slp 31/08

Date: Thursday, 8/30/2007 9:09:18 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HOUSING	<p>Per D2207 Rev. C PRELIM. 07.08.30</p>
Job Number : 34326	Part Number : D22071	
Estimate Number : 11870	Drawing Number : D2207 UNDER REVIEW	
P.O. Number : N/A	Project Number : N/A	
This Issue : 8/30/2007 S.O. No. : N/A	Drawing Revision : C	
Prsht Rev. : NC	Material : N/A	
First Issue : N/A Type : MACHINED PARTS	Due Date : 9/6/2007	Qty: 10 Um: Each
Previous Run : 33240		
Written By : <u>JD 07.08.30</u>		
Checked & Approved By : <u>JD 07.08.30</u>		
Comment : Est. A 01.03.08 New Issue		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.4375 sf(s)/Unit Total : 4.3754 sf(s)

6061-T6 .063 Sheet

5052-H32 or 6061-T6 - .063" Thick

Batch MID 5225

SAD 07/08/30

2.0	SHEAR	SHEAR
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Comment: SHEAR

Shear blanks: 4.200" x 14.00" +.000"/-.030"

Grain along 14.00"

Dwg rev C

Prog rev C

SAD 07/08/30 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA031

Deburr

Dwg rev C

Prog rev C

SAD 07/08/30

10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/30

10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Er 07/08/30

counted

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/09/12	6	split into	SK	07/09/12	9		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 07/09/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 9:09:18 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING

Job Number: 34326

Part Number: D22071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per dwg D2207

SB 07/09/12

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/12 (49)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

07/09/17 (9)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/19

Job Completion



u 07/09/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34326
Description: Housing		Part Number:	D2207-1
Inspection Dwg: D2207	Rev: B	Page 1 of 1	

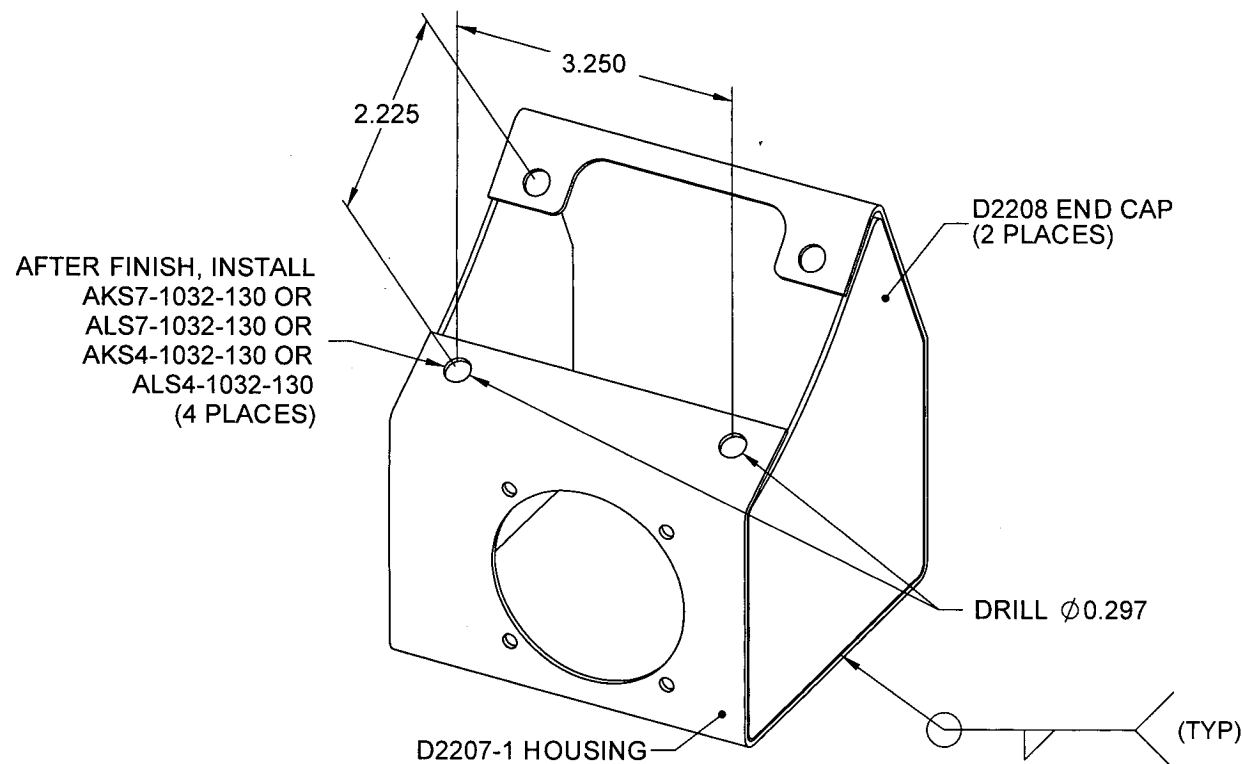
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.852	+/-0.010	0.851	✓		Vern	
R0.13	+/-0.030	R0.13	✓		R-G	
Ø0.166	+0.005/-0.000	0.166	✓		Vern	
11.630	+/-0.010	11.640	✓		Vern/Height gauge	
14.000	+/-0.010	14.063	✓		M-T	
0.923	+/-0.010	0.928	✓		Vern	
1.854	+/-0.005	1.853	✓		Vern	
1.854	+/-0.005	1.852	✓		Vern	
1.850	+/-0.010	1.853	✓		Vern	
Ø2.265	+0.005/-0.000	Ø2.265	✓		Vern	
4.200	+/-0.010	4.201	✓		Vern	
R0.300	+/-0.010	R0.300	✓		R-G	
Grain Direction	N/A		✓			
0.063	+/-0.010	0.059	✓		Vern	
Ø0.297	+0.006 -0.001	Ø0.298	✓		Vern	

Measured by:	SAD	Audited by:	En	Prototype Approval:	N/A
Date:	07/08/30	Date:	09/08/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	



D2207-041 HOUSING ASSEMBLY

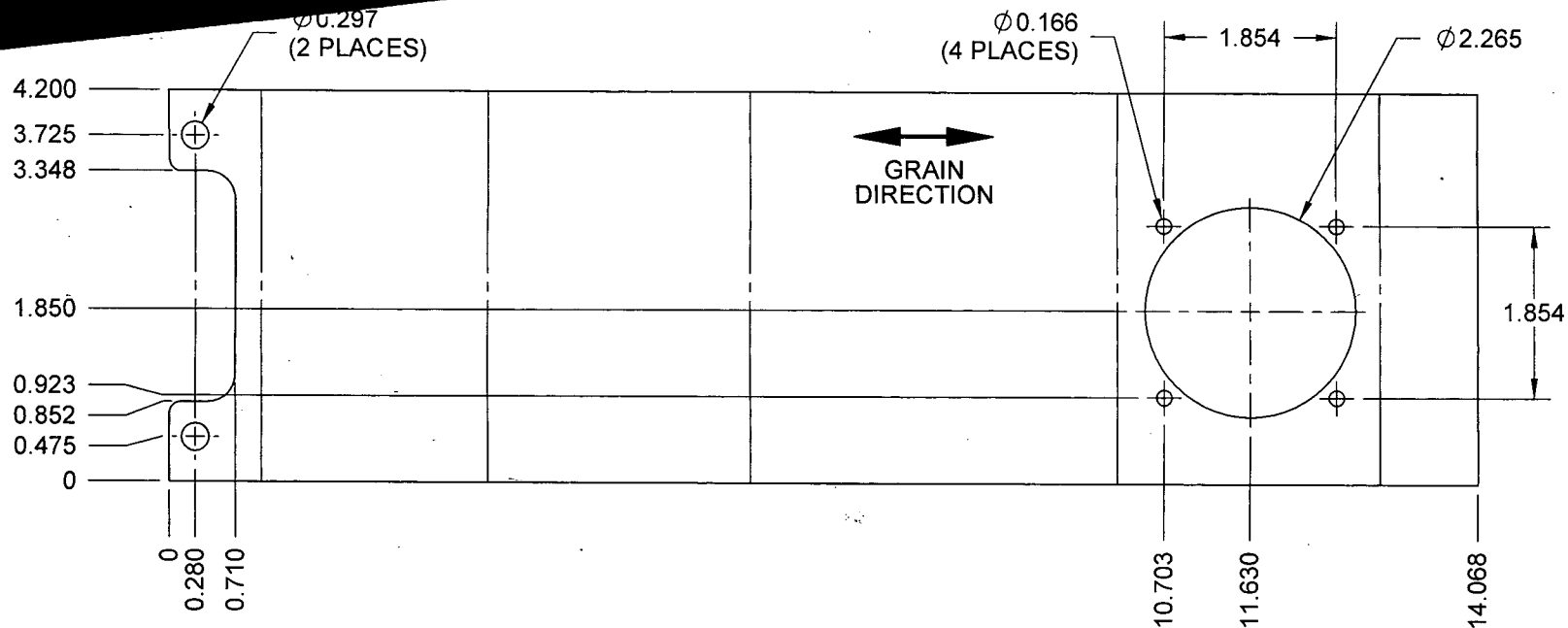
PRELIMINARY ISSUE

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34320

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>B</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BE</i>	D2207	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HOUSING	1:2
DATE	07.06.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

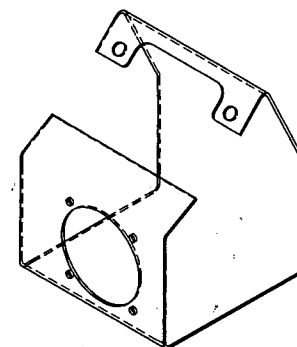


D2207-1F FLAT PATTERN

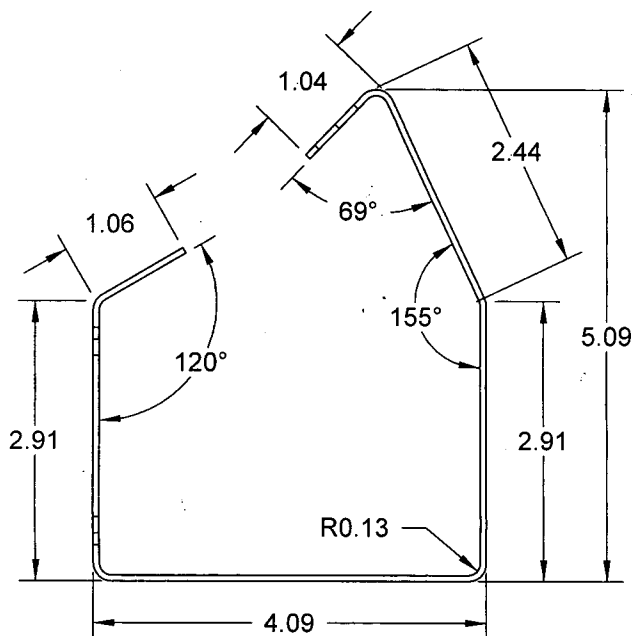
NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) **OR**
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

PRELIMINARY ISSUE



ISOMETRIC VIEW
(SCALE 1 : 4)



D2207-1 BENDING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34326

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>B</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>EE</i>	D2207	SHEET 2 OF 2
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